

Duplicate

Ship Thurs. 29/09

Work Order ID 73986



Page 1

Friday, September 23, 2011 9:56:04 AM

Item ID: D2842-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Step Assembly RH, 206 Float

Start Date: 9/20/2011 Start Qty: 5.00

Required Date: 10/4/2011 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2842

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
2-Drill D2842-1 using Jig DT8272 as per Dwg D2842
3-Deburr and bevel ends for welding

11.09.24

5

φ

105

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

11.09.26

(5x)

110

0.00



Weld per dwg A/R Aluminum rod Batch: 114514
Large Fab 117884

Large Fab

Memo

0.00

Large Fab

1-Weld one end cap and (2) lugs as per Dwg D2842
2-Grind end cap weld flush

11.09.27

5

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Setup Start



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Stop



Item Name: Step Assembly RH, 206 Float

Start Date: 9/20/2011 Start Qty: 5.00



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Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

11.09.28 (5)

5 ulabs

(75)

RH

5 BR 11-9-28.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D2842-042	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Step Assembly RH, 206 Float					
Start Date: 9/20/2011	Start Qty: 5.00		Cust Item ID:		
Required Date: 10/4/2011	Req'd Qty: 5.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				5RH	0	11/09/29	
160 Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: 114514 Large Fab Memo 1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.	0.00 0.00				5	0		11-09-29
170 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				x5			

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






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NOTE: Date & initial all entries




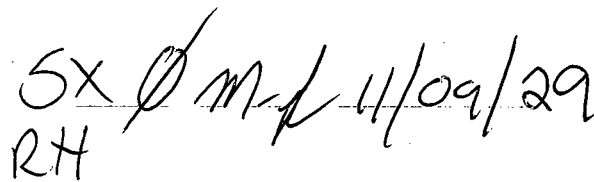

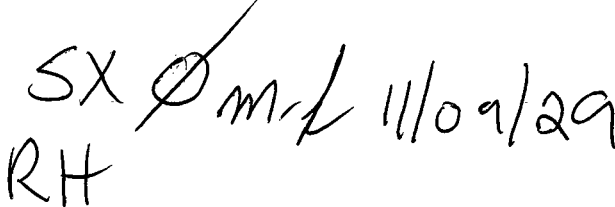
Work Order ID 73986

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Item ID: D2842-042 Accept  Setup Start 
Revision ID:
Item Name: Step Assembly RH, 206 Float Stop 
Start Date: 9/20/2011 Start Qty: 5.00  Cust Item ID:
Required Date: 10/4/2011 Req'd Qty: 5.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				 RH			
185  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo ***Touch up step with alodine per qsi 005 prior to powder coat***	0.00 0.00							 RH
190  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: OVEN TEMPERATURE: FINISH TIME:	0.00 0.00							 RH

M 118439

9:00
320 OF
9:30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes with the original objectives and goals to determine the effectiveness of the project.

Friday, September 23, 2011 9:56:04 AM

Accept

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

2. The second step is to analyze the problem. This involves breaking the problem down into smaller parts and identifying the causes.

3. The third step is to develop a plan. This involves deciding on the best way to solve the problem and setting goals.

4. The fourth step is to implement the plan. This involves putting the plan into action and making changes as needed.

5. The fifth step is to evaluate the results. This involves checking to see if the problem has been solved and if the goals have been met.

6. The sixth step is to reflect on the process. This involves thinking about what worked well and what could be improved.

7. The seventh step is to share the results. This involves telling others about what you have learned and how you solved the problem.

8. The eighth step is to continue to learn. This involves staying open to new ideas and ways of solving problems.

9. The ninth step is to be a good team player. This involves working well with others and helping them to solve their problems.

10. The tenth step is to be a good leader. This involves helping others to solve their problems and leading them to success.

Setup Start[illegible]

Stop

Stop

[illegible]**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start

[illegible]

Date:

Tooling:

Date:

Stop




[illegible]

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				5	BK	11-9-29.	
210 	HandFinishing	0.00							
HandFinish Hand Finishing	Memo 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: <u>118313</u>	0.00				5	BK	11-9-29.	
220 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00				85	RH		8 w/o 9/27

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D2842-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly RH, 206 Float

Start Date: 9/20/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 10/4/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PRP
73986

0.00

Packaging

Rec'd 8/30 (S)

240

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/30
MF
11-09-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 73986

Parent Item: D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960C10L	NAS1149C0332 R	Purchased	No			100	Each	0.0000	3	15		11-9-09	
-----------	-------------------	-----------	----	--	--	-----	------	--------	---	----	--	---------	--

washer										15.			
D2622-120C		Manufactured	No			110	Each	125.2000	1	5		11-09-23	
Step Extrusion													

Location	Loc Qty	Loc Code
HALL	115.5	
64409	6	
68293	2.5	
72131	107	
WA	9.7	
46910	2	
66970	7.7	

D2734		Manufactured	No			110	Each	46.0000	2	10		11-09-28	
Step End Plate													

Location	Loc Qty	Loc Code
WA	46	
70701	5	
73196	41	

D3459-1		Manufactured	No			110	Each	16.0000	2	10		11-09-23	
Float Step Mounting Plate													

Location	Loc Qty	Loc Code
WA017	16	
73319	16	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Friday, September 23, 2011 9:56:02 AM

Page 2

Work Order ID: 73986

Parent Item: D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 5.00

Required Qty: 5.00

D3459-3 Manufactured No

210 Each

27.0000 2 10



Float Step Mounting Plate



11.09.23

Location Loc Qty Loc Code

ST017 5

62956 5

WA 22

73320 22

MS27039C1-07 Purchased No

210 Each

54.0000 3 15



screw



11-9-29

Location Loc Qty Loc Code

ST293 54

117423 29

118686 25

NAS1329C3KB130 Purchased No

210 Each

103.0000 3 15



insert



11-9-29

Location Loc Qty Loc Code

ST276 103

117679 28

118984 75

NAS1515H3L Purchased No

210 Each

156.0000 3 15



WASHER



11-9-29

Location Loc Qty Loc Code

FG 40

102472 40

ST277 116

113362 57

118686 59

15

Friday, September 23, 2011 9:56:02 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

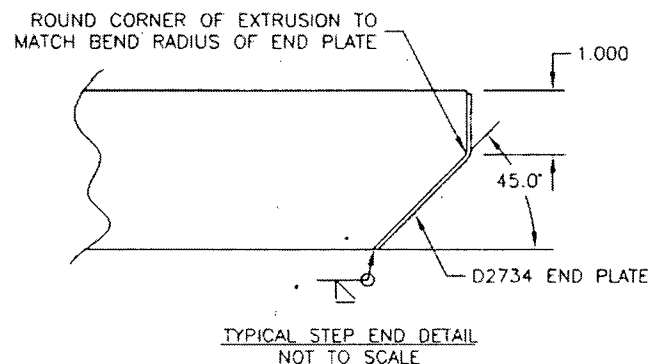
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DART AEROSPACE USA, INC.
PORT HADLOCK, WA



D2842-041/-042 FLOAT STEP ASSEMBLY

QTY -Q41	QTY -Q42	PART NUMBER	DESCRIPTION
X		D2842-Q41	LH STEP ASSEMBLY
	X	D2842-Q42	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS3KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN950C10I	WASHER

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

05-4-14

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